110

110

Large Fab

Large Fab

Large Fab

1 -Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as

0.00

required

12613.2.19

											DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPDATE		•		_	
											QA Closed:	Da	te:	
Work Ord	or:					DISPOSITION			AGAINST I	DE	PARTMENT	/PROCESS		
WOIK OIG	ei					Rework	ı		Skid-tube Crosstube]	Water Jet		Engineering
Part I	No.					Scrap		1	Machining Small Fab		Pro	d. Eng. Coor.	Н	Quality
	-					Use-as-is			noforming Finishing		4	e/Packaging	П	Other
NCR	No.					Work Order Update			Large Fab Composite			Supplier		
Root					Descri	ption of work order update		Initial	Action	_	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data									•					
Equip/Tooling				1						•			1	
Operator														
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Other				}										
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Supplier									•				-	
Training												!		
Unapproved														
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Landi	ing G	ear				General		_	_		_			
•		Bending				Bend		Grain			Ovalized			Pressure/Forced
	Ш	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	П	Cuffs				Contamination		Mainte	nance		Part Moved	•		•
		Heat Trea	t			Countersink		Mislabe	led	 	Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

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Page 2

Work Order ID 94674 December-19-12 2:26:47 PM Item ID: D3053-042 Accept *N900040100* **Revision ID:** Item Name: 212 Basket Base Assembly Start Date: 12/19/12 Start Otv: 1.00 Cust Item ID: Required Date: 1/11/13 Rea'd Otv: 1.00 **Customer:** Reference: Process Plan: Date: Tooling: Approvals: Date: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Work Center ID Description Run Hours 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *120* OC 0.00 Memo **Quality Control** 130 OC6- Inspect dimensions to drawing 0.00 *130* OC 0.00 Memo Quality Control 150 0.00 *150* Powdercoat 0.00 Memo Powder Coating START TIME: **OVEN TEMPERATUR** FINISH TIME:

1 & H13207

Setup Start

Stop

Reject

Insp.

Number Stamp

Reject

Qty

13-02-20

13-02-20

Run

Accept

Oty

Code

											DQA	: Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	CON	IFORN	MANCE / UP	DATE	QA Closed	: Date	
							1						
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS	
Part f	•					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining loforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other
NCKI	٠٠٠					Work Order opuate	ا ل		raige rab	Composite	J	Juppher [_	
Root					Descri	ption of work order update	l li	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш											1.	
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Operator								,					
Material	Ш												
Setup	•	,											
Other	Ш												ļ
Process	Ш												
Supplier	Ш												
Training	Ш							·					
Unapproved									<u> </u>				
	-					F.	AUL	T CATE	GORY				
Landi	ng G	iear				General				_	. .	_	_
		Bending			<u> </u>	Bend	Ш	Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	D/S	BOM/Route	Ш	Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorr	ect	Weld
	Ш	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/N	Aissing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Move	d	
		Heat Trea	t			Countersink		Mislabe	led		Positioned	Wrong _	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	•		Power Loss	s/Surge	Other
	1.	Ripples in	Bend			Drill Holes		Offset				_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*946	374*			Page				
tem ID:	D3053-042 212 Basket B		······································	Accept	*N900	04010) ೧ * s	Setup Start Stop	· INCTI			
Start Date: Required Date: Reference:	12/19/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:						
Approvals:		an:		-		ate:		Run Start Stop	"INK I"			
Sequence ID/ Work Center II 160 *160* QC Quality Control	Operation Description QC3- Inspect Part Memo		1	Set Up/ Run Hours 0.00	Tool ID	Tool # Plai Cod	_	Reject Qty	Reject Insp. Number Stamp			
170 *170* Packaging Packaging		Identify as per dwg & St Memo	tock Location: <u>6F)</u> W/G 9476	0.00			/K_		J. 13 /			
180 *180* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00				13/3	3/6 4)			
								Ql	13-03-6			

									DQA:	Date: _	
NCR: Y	es / No				WORK ORDER NON-C	ONFORI	MANCE / UP		QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	0.				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing				Pro	Engineering Quality Other	
NCR N	o				Work Order Update	l linen	Large Fab	Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data					•						
Equip/Tooling											
Operator		1	*								
Material											
Setup											
Other											
Process											

	FAULT CATEGORY									
Landing Gear General				_		_				
	Bending	Bend		Grain		Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure		
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld		
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled		
	Cuffs	Contamination		Maintenance		Part Moved				
	Heat Treat	Countersink		Mislabeled		Positioned Wrong		_		
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other		
	Ripples in Bend	Drill Holes		Offset		-				
	Torque Waves in Extrusion	Drawing		Out of Calibration						
	Turning Sequence	Finish		Out of Sequence						
	Wave/Twist in Tube	Folio		Outside Dimensions						

Supplier Training Unapproved Work Order ID:

94674

Parent Item:

D3053-042

Parent Item Name:

212 Basket Base Assembly

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF

III Kev.D 08-08-	2) Tevb as per av	5 00	vermed by.EC									
Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID			Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	Manufactured	No			110	Each	28.0000	2	2	10/12	2.19	
								C-2/12/2009			- /	
			Location		Loc Oty	1	Loc Code		5873	5526	\rightarrow	2)
			WA004		28							
			755	81	2							
					4			-				
			893	58	22				-	_	2	
	Manufactured	No			110	Each	95.0000	2	2	[4]	1/12	7 / 6
										-/-	c/9.0	<u> </u>
			Location		Loc Qty		Loc Code		े 🔰 है	5673	7—	≯ €
			WA004		95							_
			755	64	1							
			772	29	1							
					2							
					29							
			896	54						0		
	Manufactured	No			110	Each	86.0000	2	2	<u> C</u> pc	13.2	.19
			Location		Loc Qty		Loc Code			DES	574	/ -> (
			WA004		86				m****			
			707	'66	2							
			812	253	1							
					2						,	
					3							
								-				
			885	5/4	12							
	Replacement	Replacement Mfg/ Item ID Purch Manufactured	Replacement Item ID Mfg/ Purch No Manufactured No Manufactured No	Replacement Item ID Mfg/ Purch Bin Item Primary Location Manufactured No Location WA004 755.863.893 Manufactured No Location WA004 755.772 811 869 893 896 Manufactured No Location WA004 707 812 825 832 832 832 834 863 833 854 863 843 863 863 854 863 863 857 863 873	No Location Location Manufactured No Location WA004 75581 86362 89358 Manufactured No Location WA004 75564 77229 81144 86937 89384 89654 Manufactured No Location Location Wandfactured No Location Location	No	Manufactured No No No No No No No N	Replacement Item ID Mfg/ purch Bin purch coation Last coation Rout Seq ID Unit of Measure Manufactured Qty on Hand No Location Loc Oth P5.0000 P5.0000 P5.0000 P5.0000 P6.0000 P6.00000 P6.0000 P6.0000 P6.0000 P6.0000 P6.0000 P6.00000 P6.00000	Manufactured No	Manufactured No No No No No No No N	Replacement Mfg/ Purch Run Primary Location Count Coun	Manufactured No No No No No No No N

									DQA:	Date:	·
NCR: Ye	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap	Skid-tube Crosstube Water Jet Engir Scrap Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging					Engineering Quality Other
NCR No). 				Use-as-is Work Order Update	Thern	Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier				
Root				Descr	iption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data		•									
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process	7						1				
Supplier											
Training	7										

FAULT CATEGORY

Grain

General

Bend

Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Cuffs Maintenance Part Moved Contamination Positioned Wrong Mislabeled Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

Ovalized

Pressure/Forced

Unapproved

Landing Gear

Bending

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December-19-12 2:26:46 PM

Work Order ID: 94674 Parent Item: D3053-042 **Start Date: 12/19/12** Required Date: 1/11/13 Required Oty: 1.00 Parent Item Name: 212 Basket Base Assembly Start Otv: 1.00 D3166-1 No 100 Each 1.0000 Manufactured Basket Hoop 394945+1x Location Loc Qtv Loc Code WA006 86807 100 M304EX0.75-16F No 1.298.4313 Purchased -CC 13-02-07 Expanded Metal Flat SS Loc Qty Location > 50.526316 WA007 1298 431264 102.9036 117197 50.88673 120917 121521 0.00013372 122080 63.0699 122315 11.245 122534 160 122604 61.238 122884 36.5679 123448 288 123855 204.52 320 124070 100 CP13.2.6 M304TS0.750W.065 No 2,404.2164 43.3333 45.614 Purchased 304 SQ Tube .75x.75x.065W Location Loc Qty Loc Code MAT017 1448.153597 122468 448.153597 124069 1000 WA006 956.0628 122051 41 123303 874.0628

41

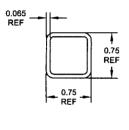
			DO	QA:	_Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			_

									QA Closea:	Date	
Work Orde	er:			,	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
			_		Rework]	Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	1	Machining Small Fab			d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update]	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	1	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data					•						
Equip/Tooling											1
Operator											
Material											
Setup											
Other											
Process											
Supplier										1	
Training											
Unapproved			<u> </u>							<u> </u>	<u> </u>
						AULT CAT	EGORY				
Landir	ng Gear	•		_	General				7	_	7
	Bending				Bend	Grain			Ovalized	<u> </u> _	Pressure/Forced
		ot Conce	ntric to C	D/S	BOM/Route	Hardw		<u> </u>	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	_	tion Incomplete	<u></u>	Part Incorre	 	Weld
		/Crimped			Burrs		ctions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination	\vdash	enance		Part Moved		
	Heat Tre	at			Countersink	Mislat	eled	<u></u>	Positioned \	_	-
		on Strip in	Tube		Cut Too Short	Misre			Power Loss,	/Surge	Other
	Ripples i	n Bend			Drill Holes	Offset					
	Torque V	Vaves in E	extrusion	ı	Drawing	Out of	Calibration				
	Turning !	Sequence			Finish	Out of	Sequence				
	Waye/Twist in Tube				Folio	Outsid	le Dimensions				

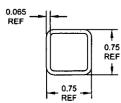
PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

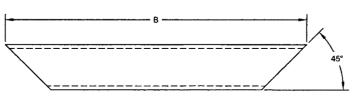
PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2		96.00	RIB
D3053-3	2		25.50	RIB
D3053-5	6	23.73		RIB
D3053-7	3	25.31		RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB

94674 N 12-20-12











1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING REF. DART SPEC M304TS0.750W.065

2) MESH MATERIAL: 3/4-16F EXPANDED SS

REF DART SPEC M304EX0.75-16F 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 7) IDENTIFICATION: NONE

8) WEIGHT: N/A

9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

10) WELD PER DART QSI 004

В		WAS 0.060 WALL. MESH MATERIAL G MOVED TO "B" FORMAT AND RENT STANDARDS.	AJS	08.07.02			
Α	NEW ISSUE	RF	01.11.01				
REV.		DESCRIPTION	BY	DATE			
DESIGN	RF	DART AEROSP	ACE	LTD			
DRAWN	AJS	HAWKESBURY, ONTAR					

CHECKED DRAWING NO. REV. B D3053 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE DE APPR. BASKET BASE ASSEMBLY (212) DATE

08.07.02

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IS PRIVATE AND CONDITION AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

ED FOR ANY PURPOSE OR CORNED OR COMMUNICATED TO ANY STHEM PERSON WITHOUT

WHAT THE PERSON PROMIDED THE STREAM PERSON WITHOUT

